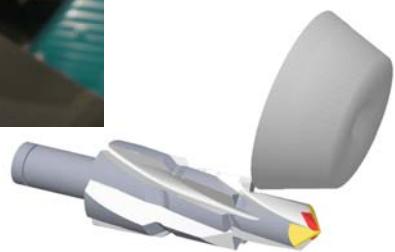


Dental Stepdrill Z6-Z3 Ø4.8 Z6

A26-510

The grinding operations to be done on this special dental drill are similar to resharpening operations on a premachined blank. Flutes and cylindrical OD's are therefore already done. The fully automatic grinding of the tool with the integrated Fanuc Robot is supported with the MicroTool Steadyrest.



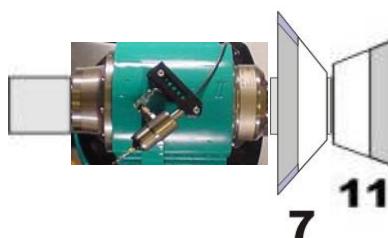
1. Cycletime for Production

Tool specifications						
Material HSS	Diameter 4.8 mm, Z 6, Length of cutting edge 7.8 mm, Helix angle 15°					
Operations	Probe	Gashing	End 2	End 1	Step 1	Step 2
Feed [mm/Min]	2000	100	100	130	120	120
Power [kW]		2	1	1	1	1
Cutting feed [m/s]		32	32	32	32	
Used wheels						
Grinding time [s]	13	23	28	25	114	126
Total cycle time	5 Min 41					

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

7	12V9 Ø125 B76
11	11V9 Ø100 B76



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG, STL 650
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 4 & 5

responsible engineer: OP,27.3.09

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

TECHNOLOGY
FOR TOOLING